Work Order ID 120613

120613

Friday, June 06, 2014 10:44:09 AM

Item ID: D4628-7 **Accept** *N9000040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Liner, Lid

Start Date: 6/6/2014 **Start Qty:** 3.00 *3* **Cust Item ID:**

Required Date: 6/6/2014 **Req'd Qty:** 3.00 *3* **Customer:**

Reference:

Approvals: **Process Plan:** MWF **Date:** 14-6-6 **Tooling:** _____ **Date:** _____ **Run Start** *NR1*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr / **Revision Nbr**									
D4628 / A									DAS 07 9-89
100		0.00							
100									
Waterjet	**Memo**	0.00				x3	____	____	____
FLOW CNC Waterjet	1-Cut as per dwg D4628 Prog rev: N/A. CUSTOM CUT. Dwg rev: A								14/06/06
	2-Deburr as per dwg								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	**Memo**	0.00				x3	____	____	DL
Quality Control									14/06/06

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

_____
_____
_____

Item ID: D4628-7 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Liner, Lid
Start Date: 6/6/2014 **Start Qty:** 3.00 *3* **Cust Item ID:**
Required Date: 6/6/2014 **Req'd Qty:** 3.00 *3* **Customer:**
Reference:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00 DAS 27 3-89				3			
120 QC Quality Control	**Memo**	0.00 M/6/6							
130	Identify as per dwg & Stock Location: GA	0.00							
130 Packaging Packaging	**Memo**	0.00				M 14-06-06			
140	QC21- Final Inspection - Work Order Release	0.00							
140 QC Quality Control	**Memo**	0.00				MLJ	14-06-09		

M 14-06-06

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Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

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Doc/Data	☐									
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Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
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☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

_____
_____
_____

Picklist Print

Friday, June 06, 2014 10:44:07 AM

Work Order ID: 120613 *120613*

Parent Item: D4628-7 *D4628-7*

Parent Item Name: Liner, Lid

Start Date: 6/6/2014 **Required Date:** 6/6/2014

Start Qty: 3.00 **Required Qty:** 3.00

Comments: IPP RevA 12.03.29 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-52068		Purchased	No			100	sf	2,713.000	0.875	3			

MKYD6185S.080-P3-52068 **

Kydex steel grey (52"x96"-.080)

Location	Loc Qty	Loc Code	
therm	2713		
119476	61		
121902	909		
122181	1049		3 sq ft
m127759	347		0
m128321	347		

DL 14/06/06

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

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Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

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Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

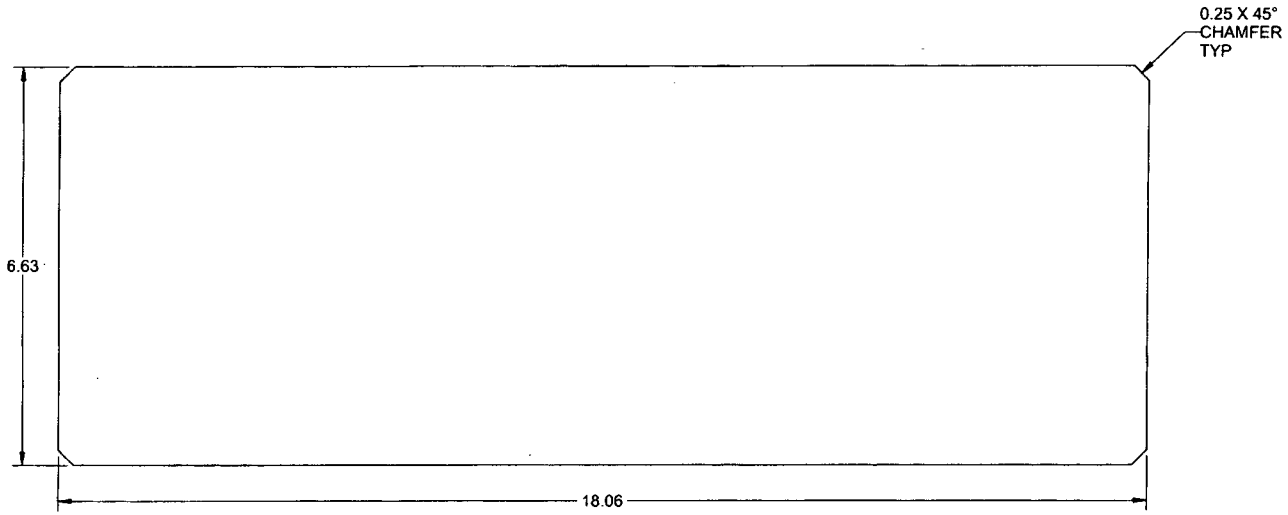
Landing Gear

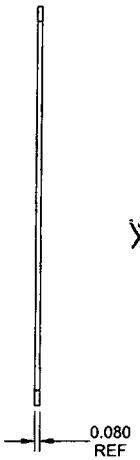
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_____
_____
_____





D4628-7 LINER, LID

RELEASED
2012 -04- 04

NOTES:
1) MATERIAL: KYDEX 6185 SHEET, VELOUR MATTE TEXTURE, WHITE (PREFERED) OR STEEL GREY(ALTERNATE) COLOR, 0.080 THICK
REF. DART SPEC. MKYD6185S.080-P3-62000 OR MKYD6185S.080-P3-52068
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4628-7" AND BATCH NUMBER "BXXXXX" PER DART QSI 044 6.4 (VIBRATING STYLUS)
7) WEIGHT: 0.42 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	ASS	DRAWING NO. D4628 — REV. A
MFG. APPR.		SHEET 4 OF 5
APPROVED		TITLE: LINER — SCALE: NTS
DE APPR.		
DATE 12.03.27		

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DQA: _____ Date: _____

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DART AEROSPACE LTD

DART AEROSPACE

Description:	LID LINER	Work Order:	170613
Inspection Drawing: D4628-7	Rev: A	Part Number:	D4628-7

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.63	+/- 0.030	6.61"	✓			
18.06	+/- 0.030					

Measured by: DL	Checked By: JB	QC inspector: DAS 27 9-89	Engineering Approval (*if necessary*):
Date 14/06/06.	Date 14/06/06	Date 14/6/6	Date

H:\FORMS\Quality Assurance\approved QA\Inspection sheet revA